ASAP

Work Order ID 1 April-30-13 2:49:35 PM			*101	115*			· •— • • • • • • • • • • • • • • • • • •		·	Page 1
Item ID: D3849-1 Revision ID:			Accept	*N900	<b>040</b>	100	)*	Setup Star Stop	1 7	S1*
Item Name: Plate Start Date: 4/29/13 Required Date: 4/30/13 Reference:	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item II Customer:	D:			50	* *N	S2*
	Plan: <u>M</u> レゴ	Date: <u> 3-05-0</u> \ Date:	Tooling: SPC (Y/N):		ate:		1	Run Stai Sto	" <b>  \</b>	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr  D3849  D3849  D00  *100  *100*  Waterjet  FLOW CNC Waterjet  SOY (050	Memo 1-Cut as per Dwg Rev:_ Prog Rev:_	<u>'O</u>	0.00				8	<u> </u>		Jn13-5-32
110 *110* QC Quality Control	2-Deburr if QC2- Inspect parts off m Memo	•	0.00				ි රි	٥		Jr 13-5-23

											DQA:	Date:	·
NCR: Y	es	/ No				WORK ORDER NON-	COI	VFORM	AANCE / UP	DATE	OA Classel	Data	
						T	·				QA Closed:	Date	: 
Work Orde	r:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	_			<u>-</u>	****	Rework	]		Skid-tube	Crosstube	]	Water Jet	Engineering
Part N	lo					Scrap	-		Machining	Small Fab	-∤	d. Eng. Coor.	Quality
NCR N	lo				<del> </del>	Use-as-is Work Order Update	_		Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root	1				Descr	iption of work order update		Initial	Ac	tion	Sign &	<del>"</del> "	
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data							T						·
quip/Tooling							1			,			
perator													
/laterial											İ		
etup											l		$1.\sqrt{2}$
Other	_											, ,	\
rocess	_								•			1	-
upplier	_									•	1	<b>,</b> , , , , , , , , , , , , , , , , , ,	
raining	_											·	
napproved	_L												<u> </u>
							FAUL	LT CATE	GORY				
Landir 1					_	General		10			Ovalized		Pressure/Forced
}		Bending			_,	Bend	$\vdash$	Grain		-	Over/Under	toloroneo	Temperature/Cure
		Centre No	ot Concer	itric to (	<sup>5)</sup>	BOM/Route	$\vdash$	Hardwa		<u> </u>	Part Incorre	<del>-</del>	Weld
		Cracks			-	Broken/Damaged	$\vdash$	-	on Incomplete	/Unclose	Part Lost/M	<u> </u>	Wrong Stock Pulled
	—	Crushed/C	rimpea		-	Burrs	-	Mainte	ions Incomplete/	Unclear	Part Moved	1551118	Twing stock i dired
	_	Cuffs Heat Trea			F	Contamination Countersink	$\vdash$	Mislabe		<u> </u>	Positioned V		
	_	neat Trea		Tubo	$\vdash$	Cut Too Short	$\vdash$	Misread		<b> </b>	Power Loss/		Other
		inspectior Ripples in		iuse	<u> </u>	Drill Holes	-	Offset	•	<u> </u>	J. 544Ci 2033/		- 3
	_	Torque W		strusio	, . <del> </del>	Drawing	$\vdash$	4	Calibration				
	-	Turning Si			` <b>-</b>	Finish	-	-1	equence				

Outside Dimensions

Wave/Twist in Tube

Folio

<b>Work Ord</b> 4 <i>pril-30-13</i> 2:4		01115		*10	1115*						Page 2
Item ID: Revision ID:	D3849-1			Accept	*N900	040	100	<b>)*</b> s	Setup Star	I ZI	S1*
Item Name:	Plate								Sto	*N	S2*
Start Date:	4/29/13	Start Qty: 8.00	*8*		Cust Item I	ID:					-, -
Required Date: Reference:	4/30/13	Req'd Qty: 8.00	*8*		Customer:						
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:	_	F	Run Stai	17	R1*
••						ate:			Sto	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC8- Inspect parts - seco	ond check	0.00	S .						
*120* QC Quality Control		Memo		0.00	( ) ( ) ( ) ( ) ( ) ( ) ( ) ( ) ( ) ( )			<u> </u>			
130				0.00				B			8/1
*130* Brake NC		Мето		0.00							Oplas
Brake NC			dwg using DT8179 & DT	T8155							
210		QC5- Inspect part compl	leteness to step on W/O	0.00	7			$\circ$			
*210*				0.00 BS	<b>24</b>			8			,
OC ·		Momo		000 15 -	`						

Quality Control

											DQA:	Date	::
NCR:	⁄es	/ No				WORK ORDER NON-	CO	NFOR	MANCE / UPDA	TE			
						-					QA Closed:	Date	e:
Work Orde						DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Work Orde	٠					Rework	1		Skid-tube (	Crosstube		Water Jet	Engineering
Part N	No.					Scrap	1	•	<b>⊢</b>	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR 1	۷o.					Work Order Update	]		Large Fab C	omposite		Supplier	
			<del>                                     </del>				1		<b>A</b> - • •		Ciara O		<del></del>
Root				٥.	1	iption of work order update		Initial	Action		Sign &	Verification	QC Inspector
Cause		Date	Step	Qty		or Non-conformance	1 Cr	nief Eng	Descripti	ion	Date	verification	QC inspector
Doc/Data	Ш	1					1						
Equip/Tooling													
Operator	Ш												
Material	Щ		}										
Setup					]								
Other													
Process	Ш											:	
Supplier													1
Training			}	1			1						
Unapproved			1	<u> </u>	<u> </u>		<u> </u>						
						F	AU	LT CATE	GORY				
Landi	ng (	Gear			_	General		-		_	1	-	<del></del>
		Bending				Bend	L	Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld .
		Crushed/	Crimped		Γ	Burrs		Instruct	ions Incomplete/Uncl	lear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		

Mislabeled Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ore		01115
Item ID:	D3849-1	
Revision ID:	·	
Item Name:	Plate	
Start Date:	4/29/13	Start Of

Page 3

April-30-13 2:4	9:35 PM			· · · [ ( ) ·	1115"					• •	Page 3
Item ID: Revision ID:	D3849-1			Accept	*N900	040	100	<b>)</b> * 9	Setup Star	* *N	S1*
Item Name:	Plate		:	·				,	Stop	*N	S2*
Start Date:	4/29/13	Start Qty: 8.00	*8*		Cust Item I	D:					
Required Date:	4/30/13	Req'd Qty: 8.00	*8*		Customer:					•	
Reference:											
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:	_	F	Run Stai	1/1	R1*
	QC:		Date:	SPC (Y/N):	D:	ate:			Sto	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		Identify as per dwg & Sto	ock Location: WAOOI	0.00					-		-
* <b>77</b> 0* Packaging Packaging		Memo		0.00				8	13-0	15-25	MAL
230		QC21- Final Inspection -	Work Order Release	0.00						1.1	/^
*230*									13	1512	794
QC		Memo		0.00					·	_/_	
Quality Control									1,0,0	5.24	

NCR:	Yes	1	No
NCK:	yes	/	140

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: Ye	es / No				WORK ORDER NON-C	LONI	-OKN	VIANCE / UP	DATE	QA Closed:	Date	:
Work Order					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part No					Rework Scrap		N	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR No	0				Use-as-is Work Order Update	]   '		noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root				Descri	ption of work order update	lni	itial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data												
quip/Tooling	4					İ						
perator	_											
/laterial	_	İ										
etup												
Other	_											
rocess	_				•							
upplier	_	ļ										
raining	4						-			1		
Inapproved		<u> </u>			_	<u> </u>		2001				<u> </u>
						AULI	CATE	JORY			-	
Landing	_			_	General				_	ا د د د	Г	Pressure/Forced
-	Bending	_			Bend	$\vdash$	arain		<b>-</b>	Ovalized		
<b> </b>	Centre No	ot Concer	ntric to C	<sup>D/S</sup>  -	BOM/Route	-	lardwa		<u> </u>	Over/Under	<del> </del>	Temperature/Cure
<u> </u>	Cracks			$\vdash$	Broken/Damaged	-	•	on Incomplete	⊢	Part Incorred		Weld
-	Crushed/	Crimped		<u> </u>	Burrs			ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
ļ-	Cuffs				Contamination	<del></del>	<b>Nainte</b>		-	Part Moved		:
-	Heat Trea			<u> </u>	Countersink	$\boldsymbol{\vdash}$	/lislabe		<u> </u>	Positioned V		7
-	Inspectio		Tube	$\vdash$	Cut Too Short	$\mathbf{H}$	/lisread		· L	Power Loss/	Surge	Other
-	Ripples in				Drill Holes		Offset					· · · · · · · · · · · · · · · · · · ·
<u> </u>	Torque W			۱ 📙	Drawing	$\mathbf{H}$		Calibration				
-	Turning S	-			Finish	$\vdash$		equence				
	Wave/Tu	ist in Tuk	ne	- 1	lFolio	I Io	Jutside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

101115

Parent Item:

D3849-1

Plate Parent Item Name:

**Start Date:** 4/29/13

Required Date: 4/30/13

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP REV:A NEW ISSUE 12-08-23 JLM VERIFIED BY:DD

DWG REV D. DD. VERE-II M.

IPP Rev:B 12.09.11 AS PER

1.529894

90.84

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>M304S18GA</b> 304/316 .050 Sheet		Purchased	No			100	sf	287.6699	3.585	30 <del>.18947</del> 4 3 i			Jm13.5-8
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT019		193.3							
				117	188	5							
				117	766	5							
				120	604	5							
				122	325	3							
				123	155	3							
					572	172.3							
				MAT020 13	2225	94.369894			12:	5 <i>5</i> 53			

120243 121626

124029

NCD.	V	,	N 1 -
NCR:	Yes	/	No

DQA: \_\_\_\_ Date: \_\_\_\_

NCR: Ye	es / No				WORK ORDER NON-C	CONFO	RMAN	CE / UP	PDATE			
										QA Closed:	Date	:
Work Order	<u>.</u>				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	<del></del>		1		Rework	1	Skid-t	ube	Crosstube		Water Jet	Engineering
Part No	o.				Scrap	]	Machir	ning	Small Fab	Pro	d. Eng. Coor.	Quality
				<del></del>	Use-as-is	Th	ermoforn	ning	Finishing	Rec/Sto	re/Packaging	Other
NCR No	0				Work Order Update	]	Large	Fab	Composite	]	Supplier	
Root				Descri	ption of work order update	Initia		Ac	ction	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief E	ng	Desc	cription	Date	Verification	QC Inspector
oc/Data	_											·
quip/Tooling						ł						
perator	_						1					
/laterial	_						ì					· .
etup	_	1										
Other	_											
rocess	_	•										
upplier	4	ļ										
raining	_	ļ										
inapproved		<u> </u>		<del></del>		AULTC	ATEGORY					1
					General	AULI CA	TEGORT					
Landin	<b>-</b>				Bend	Gra	in		_	Ovalized	Г	Pressure/Forced
-	Bending Centre No	at Cansa	atric to (	\s\ \-	BOM/Route	$\vdash$	dware		-	Over/Under	tolerance	Temperature/Cure
-	Cracks	ot Concei	itric to t	) <sup>3</sup>  -	Broken/Damaged	$\vdash$	ection Inco	omnlete		Part Incorre	<del> </del>	Weld
}	Crushed/	Crimpod		H	Burrs		ructions In		/Unclear	Part Lost/Mi	<b> </b>	Wrong Stock Pulled
-	Cuffs	Cittipeu		<u> </u>	Contamination		intenance		-	Part Moved		7 2.18 2.22 222
	Heat Trea	<b>.</b> +		·	Countersink	$\boldsymbol{\vdash}$	labeled	•		Positioned V	Vrong	
-	Inspectio		Tuho	-	Cut Too Short	$\vdash$	read		<u> </u>	Power Loss/		Other
<b> </b>	Ripples in	-	rușe	·  -	Drill Holes	Offs			L_	7. 2 5333/		1
F	Torque W		ytrusio	,一	Drawing	$\vdash$	of Calibrat	tion				
<b> </b>	Turning S			·	Finish	$\vdash$	of Sequen					
}	Wave/Tw			H	Folio	$\vdash$	side Dimer					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	101115
Description: Wearplate	Part Number:	D3849-1
Inspection Dwg: D3849 Rev: D		Page 1 of 1

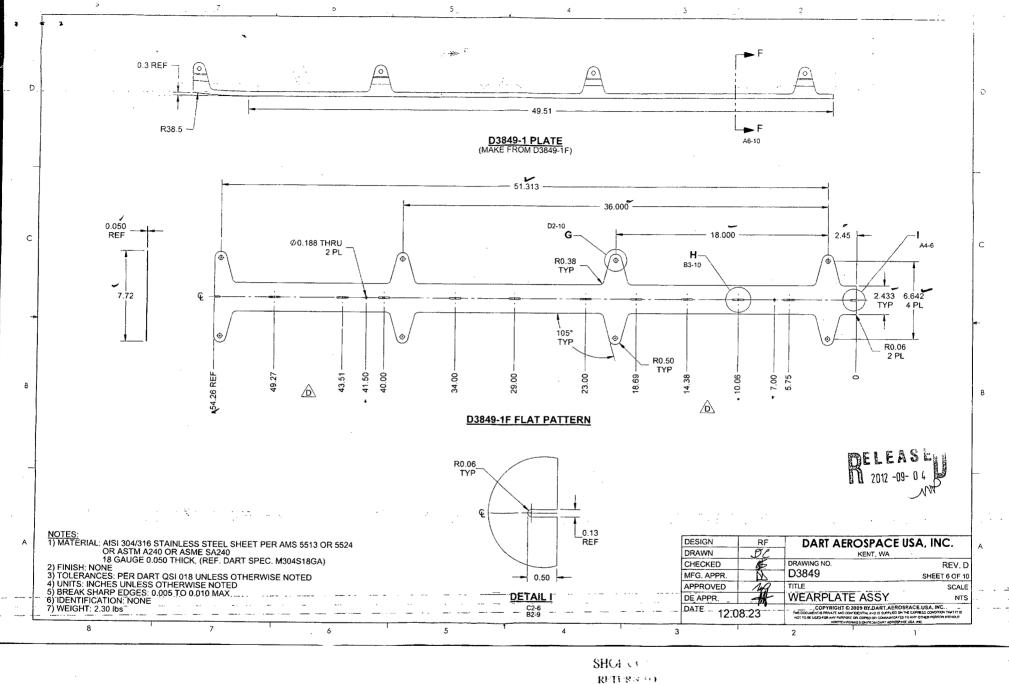
## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+0.006/-0.001	0,377"	_		V	Jamoi
0.125	, +/-0.010	0.132,	_		ν	
0.88	+/-0.030	0.882	_		. V	
2.433	+/-0.010	2.434"	~		V	
6.642	+/-0.010	6.640"	-		J	
2.45	+/-0.030	2.45	_		. V	
18.000	+/-0.010	18.000"	-		T	JEMOG
€ 36.000	+/-0.010	36.000"	-		σ	
. 51.313	+/-0.010	S1.313"	-		Τ	
7.00	+/-0.030	41.50"			V	
41.50	+/-0.030	41.50	_		・サ	
7.72	+/-0.030	7.712"	-		V	
54.26	+/-0.030	54.26"	_		T	
0.050	+/-0.010	6043	-		· Y	
:						
				,		·
- 4						

Measured by: Jim	Audited by:	OAG 27	Preliminary Approval:	
Date: 13-5-22	Date:	K 3 22	Date:	

Rev	Date	Change	Revised by	Approved
Α	09.10.01	New Issue P/O D3849-041	KJ 1	
В	12.10.26	Dimensions updated per Dwg Rev D	KJ 🗘	W

80



SHOLCO
RETURN OF
ENGINE AND THE
UNCONTROLL OF COMMENCE
SUBJECT TO AMERICAN
WITHOUT MA
WORLORLS MCS
NOLLO LINS MCS
13-05-01

